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Dart Aerospace Ltd.
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RBEA62309
Job Sheet 179193



Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 8/30/18

Created By: Logan David

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	8/30/18	8/30/18	0.00	0.00	Start Up Small Fab-4		
105	Small Fab	1 pcs	8/30/18	8/30/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs	8/30/18	8/30/18	0.00	0.00	QC5		
130	Packaging	1 pcs	8/30/18	8/30/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea	8/30/18	8/30/18	0.00	0.00	QC21		

Part Op 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses



Container No: S111068



Part: RBEA62309

Job No: 179193

Serial No/Batch: S111068

Revision: 12

Inspector:

Exp Date:

Instructions:

Date: 09/18/18

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NOV 9 1905

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Start up Operation	5021040
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	105-Small Fab	5038398
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab	5038398 5038431
7189K31	Cable Ties Black	9 Ea (9 ea)	105-Small Fab	5038430
86625K31	Grommet Size 00	1 Ea (1 ea)	105-Small Fab	5038427
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab	5094609
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab	5075949
97526A421	Rivet	4 Ea (4 ea)	105-Small Fab	5038428
APP-1700-E	Hard Case	1 Ea (1 ea)	105-Small Fab	5092386
CL-194-TERM-2	Eyelet	1 Ea (1 ea)	105-Small Fab	5041609
CL-2-C	Lanyard Wire	1.1600 ft (1.16 ea)	105-Small Fab	5093863
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab	50942292
141A RBE-350DAMPER	Damper Spanner Wrench	1 Ea (1 ea)	105-Small Fab	5107750
141A RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 Ea (1 ea)	105-Small Fab	5115954
77 RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab	5064583
141 RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 Ea (1 ea)	105-Small Fab	5115851
RBE-350TEMP	Temperature Probe	1 Ea (1 ea)	105-Small Fab	5098179
RBE350A93-3200-20	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 Ea (1 ea)	105-Small Fab	5109419
RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096004
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5098015
RBE350A93-3300-20	Tail Rotor Hub Socket	1 Ea (1 ea)	105-Small Fab	5117389
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 Ea (1 ea)	105-Small Fab	5123228
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 Ea (1 ea)	105-Small Fab	5117835
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 Ea (1 ea)	105-Small Fab	5120027
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 Ea (1 ea)	105-Small Fab	5121659
141A RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 Ea (1 ea)	105-Small Fab	5121708
RBE350A93-3316-20	Rotating Star Replacement Wrench	1 Ea (1 ea)	105-Small Fab	5107555
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 Ea (1 ea)	105-Small Fab	5101575
RBE350A93-3400-00	Drive Shaft Thimble	1 Ea (1 ea)	105-Small Fab	5115898
RBE350A93-3500-00-1	Bearing Extractor	1 Ea (1 ea)	105-Small Fab	5113151 5099402
141 RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 Ea (1 ea)	105-Small Fab	5113050
141A RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	105-Small Fab	5113008
141B RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	105-Small Fab	5121877
141B RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	105-Small Fab	5113844
141B RBE350A94-3301-00	T/R Accelerator Support	1 Ea (1 ea)	105-Small Fab	5113375
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 Ea (1 ea)	105-Small Fab	5115529
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	105-Small Fab	5181970
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	105-Small Fab	5101757
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 Ea (1 ea)	105-Small Fab	5117215
76 RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 Ea (1 ea)	105-Small Fab	5108687 5103310
72 RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	1 Ea (1 ea)	105-Small Fab	5116692
RBE703A95-0508-00	Main Rotor Gear Box Drain Tube	1 Ea (1 ea)	105-Small Fab	5111831
RBE703A95-0520-01	Engine And Hydraulic Drain Tube	1 Ea (1 ea)	105-Small Fab	5082598
RBE703A95-0520-01-11	Tube	1 (1 ea)	105-Small Fab	/ / /
RBE703A95-0520-01-13	Cap	1 (1 ea)	105-Small Fab	/ / /
RBE703A95-0520-01-15	Foam	1 (1 ea)	105-Small Fab	/ / /
RBEA62309-65	Laminated Location Card	1 Ea (1 ea)	105-Small Fab	5038322
RBEA62309-81	Top Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092349
RBEA62309-82	Top Cushion Stiffener	1 Ea (1 ea)	105-Small Fab	5092364
RBEA62309-83	Bottom Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092379
135 RBEA62310	AS350/355 Engine Strut	1 Ea (1 ea)	105-Small Fab	5113281
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab	5095819
102 RBW109-3101-58-1-1	Hammer, Steel	1 Ea (1 ea)	105-Small Fab	5121282
102 RBW109-3101-58-2-1	Hammer, Aluminum	1 Ea (1 ea)	105-Small Fab	5089089
				5021355

Job Allocations

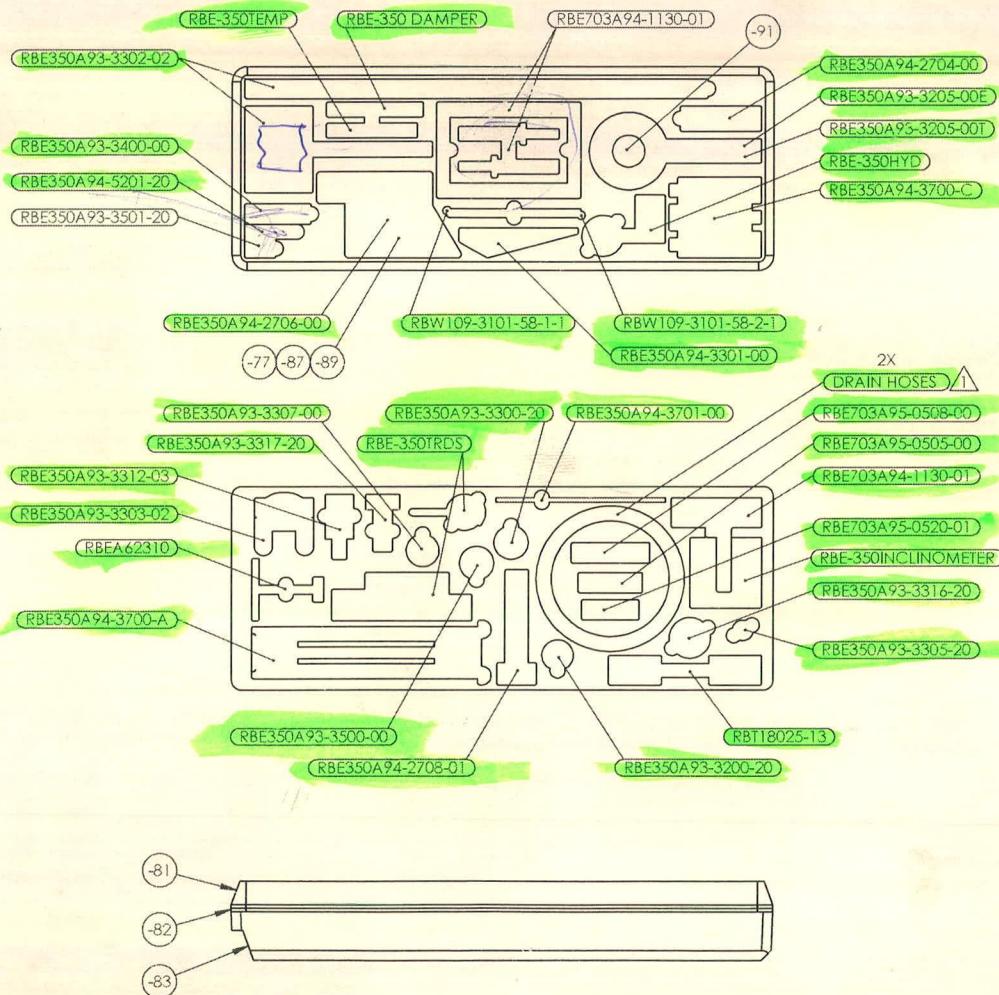
Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	RB41011	1	887	0
105-Small Fab	3896T31	2	498	0
	5274T761	1	10	0
	7189K31	9	1,000	0
	86625K31	1	50	0
	9052000	4	36	0
	97524A032	4	383	0
	97526A421	4	100	0
	APP-1700-E	1	17	0
	CL-.194-TERM-2	1	50	0
	CL-2-C	1	319	0
	NAS1756-12	1	377	0
	RBE-350DAMPER	1	1	0
	RBE-350HYD	1	10	0
	RBE-350INCLINOMETER	1	14	0
	RBE-350TDRS	1	9	0
	RBE-350TEMP	1	1	0
	RBE350A93-3200-20	1	1	0
	RBE350A93-3205-00E	1	8	0
	RBE350A93-3205-00T	1	9	0
	RBE350A93-3300-20	1	12	0
	RBE350A93-3302-02	1	0	0
	RBE350A93-3303-02	1	1	0
	RBE350A93-3305-20	1	0	0
	RBE350A93-3307-00	1	1	0
	RBE350A93-3312-03	1	0	0
	RBE350A93-3316-20	1	1	0
	RBE350A93-3317-20	1	1	0
	RBE350A93-3400-00	1	1	0
	RBE350A93-3500-00	1	0	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	10	0
	RBE350A94-2706-00	1	1	0
	RBE350A94-2708-01	1	1	0
	RBE350A94-3301-00	1	13	0
	RBE350A94-3700-A	1	2	0
	RBE350A94-3700-C	1	0	0
	RBE350A94-3701-00	1	29	0
	RBE350A94-5201-20	1	11	0
	RBE703A94-1130-01	1	1	0
	RBE703A95-0505-00	1	1	0
	RBE703A95-0508-00	1	3	0
	RBE703A95-0520-01	1	0	0
	RBE703A95-0520-01-11	1	0	0
	RBE703A95-0520-01-13	1	0	0
	RBE703A95-0520-01-15	1	0	0
	RBEA62309-65	1	35	0
	RBEA62309-81	1	8	0
	RBEA62309-82	1	13	0
	RBEA62309-83	1	8	0
	RBEA62310	1	1	0
	RBT18025-13	1	17	0
	RBW109-3101-58-1-1	1	6	0
	RBW109-3101-58-2-1	1	0	0

Part Specifications

Specifications could not be found.

Plex 6/14/18 11:46 AM dart.logan.david

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REV		ECR		DESCRIPTION	DATE	INITIAL	APPROVED
1				-81 REARRANGED TOP SHELF TOOLS. -83 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -45 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATOR CARD AND LANTARD COMPONENTS.	9/22/2009	WP	
2				REDRAWN TO USE HELI-PRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES.	1/25/2010	WP	RW
2A				ADDED NEW RED BARN PHOTOS.	2/11/2010	RJC	RW
3				-81 REARRANGED TOP SHELF TOOLS. -83 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA703A94-1130-01. CHD CUTOUT DEPTH FOR RBEA703A94-1130-01. -45 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. CHD CARD INFORMATION FOR LA 5.	2/18/2010	RJC	
4				-83 REARRANGED TOOL CUTOUTS. ADDED CUT OUT FOR RBEA62310. -45 UPDATED CARD.	3/9/2010	WP	
4A				-49 & -51 CHD QTY. FROM 3 TO 1 SET. UPDATED LAYOUT PHOTOS.	5/26/2010	RJC	
4B				-87 & -89 ADDED ONE TO EACH QTY.	7/21/2010	WP	RW
4C				-91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-05 NUTS & BOLTS.	10/27/2010	WP	DW
5				-81 DELETED CUTOUT NOTCHES FOR RBEA62310-15.	6/20/2011	RJC	RW
6				CORRECTED DRAIN HOSE 1/4" FROM RBEA95-0520-01 TO RBEA95-0520-01. -83 CHD FOAM CUTOUTS FOR RBEA93-3300-20, RBEA93-3300-20, RBEA93-3317-20 FOR BETTER FIT. -45 UPDATED CARD.	2/27/2012	RJC	DW
7				-83 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUTS FOR INDIVIDUAL CUBICLES. CHD CUTOUT FOR RBEA94-3700-A FOR TIGHTER FIT. -45 UPDATED CARD.	1/9/2013	RJC	SE
7A				-45 CORRECTED ITEM QTY FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD QTY. FROM 8 TO 1. ADDED 1 DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D, AND X1, X2, & X3 TO X.	4/11/2013	RJC	RJC
8				-81 CHD DIM WAS 4.75 B 4.44. -83 CHD CUTOUT LOCATION FOR RBE350A94-3700-A. -45 CORRECTED 1/4" & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.	10/24/2013	CFS	DW
9				-81 CHD CUTOUT FOR RBE-350HYD (NEW GAUGE). CHD CUTOUT FOR RBE350A94-3700-C TO FIT BETTER. -83 CHD CUTOUT FOR RBE350A94-3700-A TO SECURE TOOLS BETTER.	3/25/2014	RJC	DW
10	15-0038			UPDATED TO NEW DRAFTING STANDARDS. -83 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -45 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER.	2/11/2015	DPD	JAG
11	16-0149			-81 ADDED DETAIL SHEET. REPLACED RBE-RODS-15 WITH RBT18025-13 AND MOVED TO -83. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS 720 BLACK B ETHAFOAM 220. BLACK. -82 ADDED DRAWING. -83 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X R.64 IS 3X .64 & 45. DELETED DIMS: 75 (2), 14" (2), 1.38 (2), & 6.75 (4) SPHERE. AND ADDED DIMS: 75, 1.45 & 1.25. CHD FOAM WAS 720 BLACK B ETHAFOAM 220. BLACK. MOVED RBE350A93-3400-00. RBE350A93-3501-20 & RBE350A93-3501-20 TO -81. -83 RBE-RODS-15 REPLACED W/ RBT18025-13. -45 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1, RBW109-3101-58-2, RBT18025-13, -77, -87, & -89.	9/20/2016	RJC	JAG
12	17-0013			-81 CHD DIM WAS 8.00 B .82. -83 CHD DETAIL E ORGANIZATION: REMOVED DIM 3X 9.88, 3X 1.38, 3X 47, 2X 34.17, 2X 2.25, 6.07, 7.13. ADDED DIM 67.75, 30.13, 5.49, 12.77, 7.13, 91.38, 5X 9.50, 2X 9.65, 6X 13, 9.50, CHD DIM WAS 10.24 B 3X 10.24, WAS 2X 34.88 B 3X 34.88, WAS 12.33 B 6.80, WAS 11.565 B 11.57. -45 REARRANGED TOOLS ON BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.	1/24/2017	SM	JAG

NOTE:

7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

DART AEROSPACE	
TITLE AS350-355 FIELD MAINTANANCE KIT	
DWG NO. RBEA62309	REV 12
MAT'L FEAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS = 16
FINISH XX	ANGLES ±1°
SPEC XX	SURFACES ±125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES ±.015 ± .05° OR .015R
CHECKED BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OP'S APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AS350/355
SCALE 1:8	DATE 9/20/2016
SHEET 1 OF 8	

